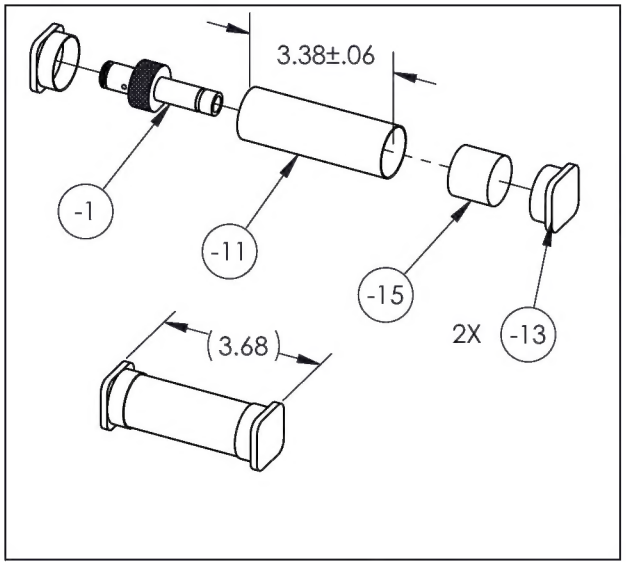
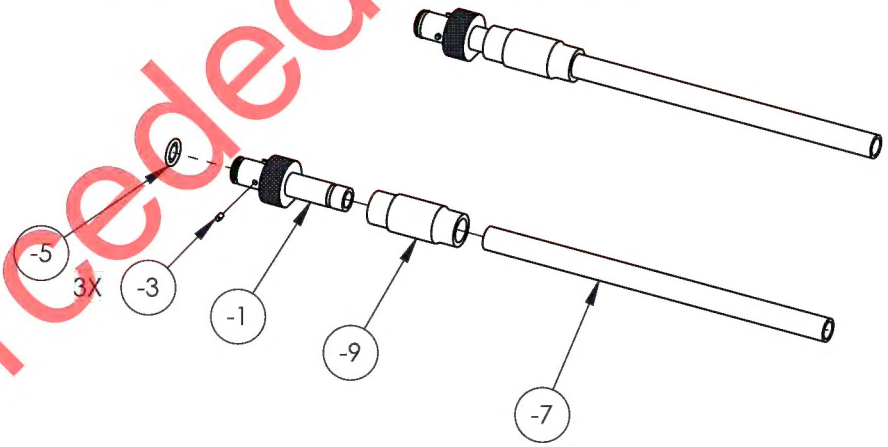
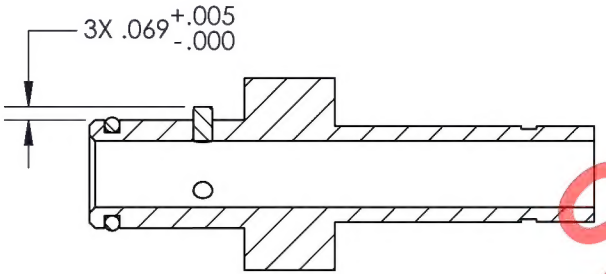
REVISIONS

REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
1		ADDED SECOND FLAT TO ENGRAVE S/N & "MADE IN USA", ADDED NOTE TO DETAIL.	5/22/2009	RJC	
2		CH'D P/N -1 MATERIAL FROM STRESS PROOF & FINISH SPEC TO RED ANODIZE PER WP & DW , ADDED MIL SPEC PER WP.	10/29/2009	RJC	RW
3		MODIFIED -1 TO WORK WITH COUPLING, ADDED COUPLING, DELETED HOSE CLAMP. CH'D HOSE FROM Ø5/8 TO Ø1/2, ADDED TUBE, CAPS, & SPONGE	7/31/2012	JAG	
3A		CH'D T/N WAS RBEA95-0520-01 IS RBE703A95-0520-01.	6/19/2013	BIM	RW
3B		CH'D TOOL NAME WAS POWERPLANT & HYDRAULIC RESERVOIR DRAIN TOOL IS ENGINE & HYDRAULIC DRAIN TUBE.	11/7/2013	RJC	RW
3C		**-11** CH'D DIM WAS 3.48 IS 3.38. **-15** CH'D MATERIAL TO NEW PIG CORP. #PAD210.	2/5/2014	DPD	RW
3D		**-7** CH'D LENGTH OF HOSE WAS 6 FEET IS 7 FEET.	3/26/2014	RJC	DW
4	14-0209	CH'D TITLEBLOCK WAS RED BARN IS DART. **-1** REMOVED .059 LIP FROM INPUT SIDE OF QUILL. CH'D DIM WAS Ø1.00 IS (Ø1.00). DELETED DIM 3X .591. ADDED DIM 3X .216. CH'D B/O INFO WAS Ø3/4 X 2-7/8 IS Ø1 X 2-7/8.	11/4/2014	DPD	JAG



SEE ATTACHED DEVIATION





-1 PRESS DETAIL
SCALE 1 : 1

UNDER REVIEW

URF 19-561 19.02.05 (KPT)

FUNCTION: USED TO DRAIN OIL SYSTEMS; ARRIEL POWER PLANT & HYDRAULIC RESERVOIR.

ORIGINAL No. REFERENCE
RBEA95-0520-01 = 703A95-0520-01 = E-350-2 = 881218700

ASSY QTY	ASSY QTY	B/O	Part #	UNIT QTY	Description	Material	B/O INFORMATION OR SPECIFICATIONS	PG.
			-1	1	QUILL	6061	Ø1 X 2-7/8	2
		B/O	-3	3	DOWEL PIN	S.S.	Ø2.5mm x 6mm MCMASTER-CARR #91585A030	1
		B/O	-5	1	O-RING	VITON	Ø15mm OD x 2mm WIDTH MCMASTER-CARR #9263K519	1
		B/O	-7	1	HOSE	VINYL	Ø1/2 O.D. x Ø3/8 I.D. x 6ft KURI-TECH #K010-0608	1
		B/O	-9	1	COUPLING	NICKEL-PLATED BRASS	Ø1/2 MCMASTER-CARR #51495K116	1
		B/O	-11	1	TUBE	POLYETHYENE	Ø1.09 MCMASTER-CARR #2044T47	1
		B/O	-13	2	CAP	VINYL	Ø1.09 MCMASTER-CARR #2044T67	1
		B/O	-15	1	FOAM	POLYESTER/POLYURETHANE	Ø1 X 1 NEW PIG CORP. #PAD210	1

DART AEROSPACE

TITLE: ENGINE & HYDRAULIC DRAIN TUBE

DWG NO. RBE703A95-0520-01 REV 4

MAT'L

DRAWN BY: PERRITT

APPROVED D Weil

HEAT TREAT

FINISH

SPEC

UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES
.XXX ± .005 FRACTIONS ± 1/8
.XX ± .01 ANGLES ±.5°
.X ± .1
1. BREAK ALL SHARP EDGES .015 x 45° OR .015R
2. DIMENSIONAL LIMITS APPLY AFTER PLATING

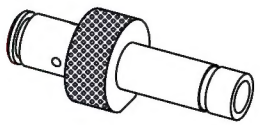
USED ON MODEL: EUROCOPTER AS350A

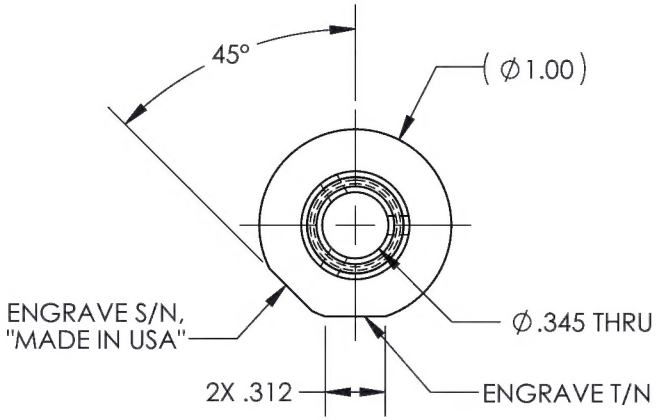
SCALE 1:4 DATE 11/10/2008 SHEET 1 OF 2

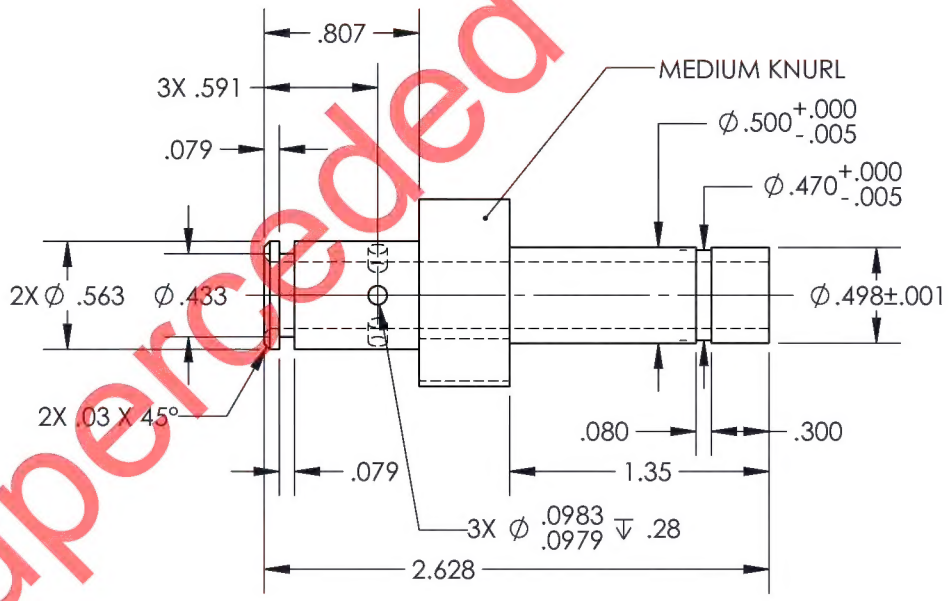
REVISIONS

REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
1		ADDED SECOND FLAT TO ENGRAVE S/N & "MADE IN USA", ADDED NOTE TO DETAIL	5/22/2009	RJC	
2		CH'D P/N -1 MATERIAL FROM STRESS PROOF & FINISH SPEC TO RED ANODIZE PER WP & DW , ADDED MIL SPEC PER WP.	10/29/2009	RJC	RW
3		MODIFIED -1 TO WORK WITH COUPLING	7/31/2012	JAG	
4	14-0209	-1 REMOVED .059 LIP FROM INPUT SIDE OF QUILL. CH'D DIM WAS Ø1.00 IS (Ø1.00). DELETED DIM 3X .591. ADDED DIM 3X .216.	11/5/2014	DPD	JAG

SEE ATTACHED DEVIATION







UNDER REVIEW

URF 19-561 19.02.05 (KPT)

(-1)

QUILL

DART AEROSPACE

TITLE: ENGINE & HYDRAULIC DRAIN TUBE

DWG NO. RBE703A95-0520-01-1		REV 4
MAT'L 6061	DRAWN BY: PERRITT	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX ± .005 FRACTIONS ± 1/8 .XX ± .01 ANGLES ±.5° .X ± .1 1. BREAK ALL SHARP EDGES .015 x 45° OR .015R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING	APPROVED D Weil HEAT TREAT FINISH RED ANODIZE SPEC MIL-A-8625F, TYPE II, CLASS II USED ON MODEL EUROCOPTER AS350A	
SCALE 1:1	DATE 11/10/2008	SHEET 2 OF 2

Entered: _____ Date: _____

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No.

Route update only ☐

Job: _____

Part No. RBE703A95-0520-01 Rev. 4

DISPOSITION

Rework	☐
Scrap	☐
Use-as-is	☐

DEPARTMENT/PROCESS

Skid-tube	☐	Cross tube	☐	Eng. (Non-AW)	☐	Engineering	☐
Machining	☐	Small Fab	☐	Prod. Eng. Coor.	☐	Water Jet	☐
Large Fab	☐	Finishing	☐	Rec/Store/Packaging	☐	Supplier	☐
						Quality	☐

Date :

Sequence #:

QTY Affected :

MRB (QSI042)

Oct 30, 2018

Description Work Order Deviation

Kuri-Tech Hose (K010-0608) easily pulls out of Coupling (McMaster Carr 51495K116)

Disposition

Install a 1.0" long, 0.38" OD, 0.25" ID piece of Stainless Steel into one end of the Kuri-Tech Hose until flush.

Attach the modified end of the Kuri-Tech Hose to the Coupling before placing tool into packaging (if applicable).

This deviation is acceptable.

The fit, form and function of the part will be as originally intended.

Completed By

Lead hand / Supervisor

QC / QA Coordinator

UNDER REVIEW

Superceded

URF 19-561 19.02.05 (KPT)

Root Cause

Operator	☐
Manufacturing Process	☐
Equip/Tooling	☐
Handling/Presservation	☐
Material	☐
Product Improvement	X
Process Improvement	☐
Human Factors	☐

FAULT CATEGORY

☐ Pressure/Forced	☐ Contamination	☐ Power Loss/Surge	☐ Positioned Wrong
☐ Bending	☐ Misaligned/off center	☐ Folio/Program	☐ Outside Tolerance
☐ Crushing	☐ BOM/Route	☐ Grain Direction	☐ Drawing
☐ Cracks	☐ Broken/Damage/Defect	☐ Weld	☐ Finish
☐ Crimp/Kink/Ripple/Wave/Twist	☐ Incomplete/Unclear Instructions	☐ Wrong Stock Pulled	☐ Part Lost/Missing
☐ Marks/Chatter	☐ Drill Holes	☐ Out of Sequence	☐ Misread
☐ Mislabeled	☐ Fit/Function	☐ Off-set/Set-up	

Other/Details: